

Date: Tuesday, 10/03/2009 11:27:48 AM  
User: Linda Lacelle

# Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : WEARPLATE
<b>Job Number</b> : 46397	
<b>Estimate Number</b> : 13459	
<b>P.O. Number</b> :	<b>Part Number</b> : D38051
<b>This Issue</b> : 10/03/2009 <b>S.O. No.</b> :	<b>Drawing Number</b> : D3805 REV.A
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : / / <b>Type</b> : SMALL /MED FAB	<b>Drawing Revision</b> : A
<b>Previous Run</b> : 45479	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 16/03/2009 <b>Qty:</b> 2 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> :	
<b>Comment</b> :	
Est Rev:A 08-07-15 new issue DD verified by:EC	
Est Rev:B 08-07-30 redesign flat pattern DD verified by:EC	
Est Rev:C 08-09-23 redesign flat pattern DD verified by:EC	
Est Rev:D 09-03-04 rev.a as per dwg DD verified by:EC	

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	M304S18GA	304/316 .050 Sheet
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**Comment:** Qty.: 2.0110 sf(s)/Unit Total : 4.0219 sf(s)  
304/316 .050 Sheet  
batch: 108156

ml 09 03 10

②

2.0	WATER JET	FLOW WATER JET
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**Comment:** FLOW WATER JET  
1-Cut as per Dwg D3805  
Dwg Rev: A  
Prog Rev: A

2-Deburr if necessary

ml 09 03 10

②

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

ml 09 03 10

②

4.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECK

09.03.10 ②

5.0	BRAKE NC	NC BRAKE
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**Comment:** NC BRAKE  
Form as per Dwg D3805 using Jigs DT8261 and DT8326

SB 09/03/11 ②

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Tuesday, 10/03/2009 11:27:49 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE

Job Number: 46397

Part Number: D38051

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: W/O B46394

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF  
09-03-13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

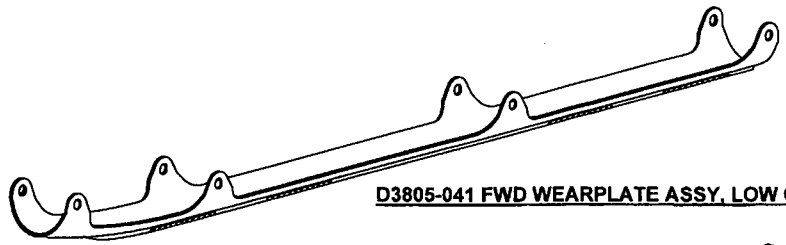
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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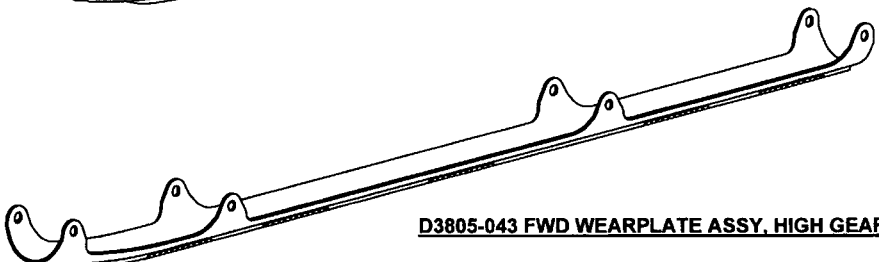
8 7 6 5 4 3 2 1

D



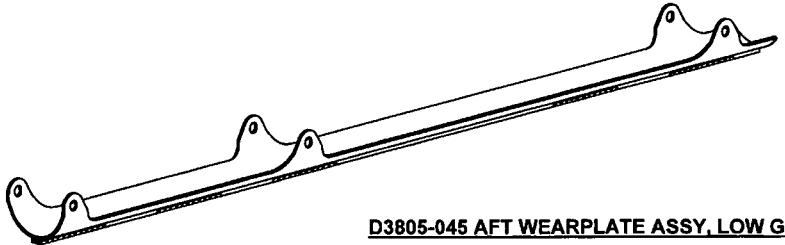
D3805-041 FWD WEARPLATE ASSY, LOW GEAR

C



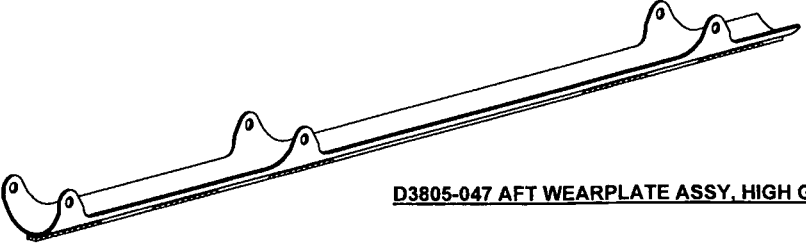
D3805-043 FWD WEARPLATE ASSY, HIGH GEAR

B



D3805-045 AFT WEARPLATE ASSY, LOW GEAR

A



D3805-047 AFT WEARPLATE ASSY, HIGH GEAR

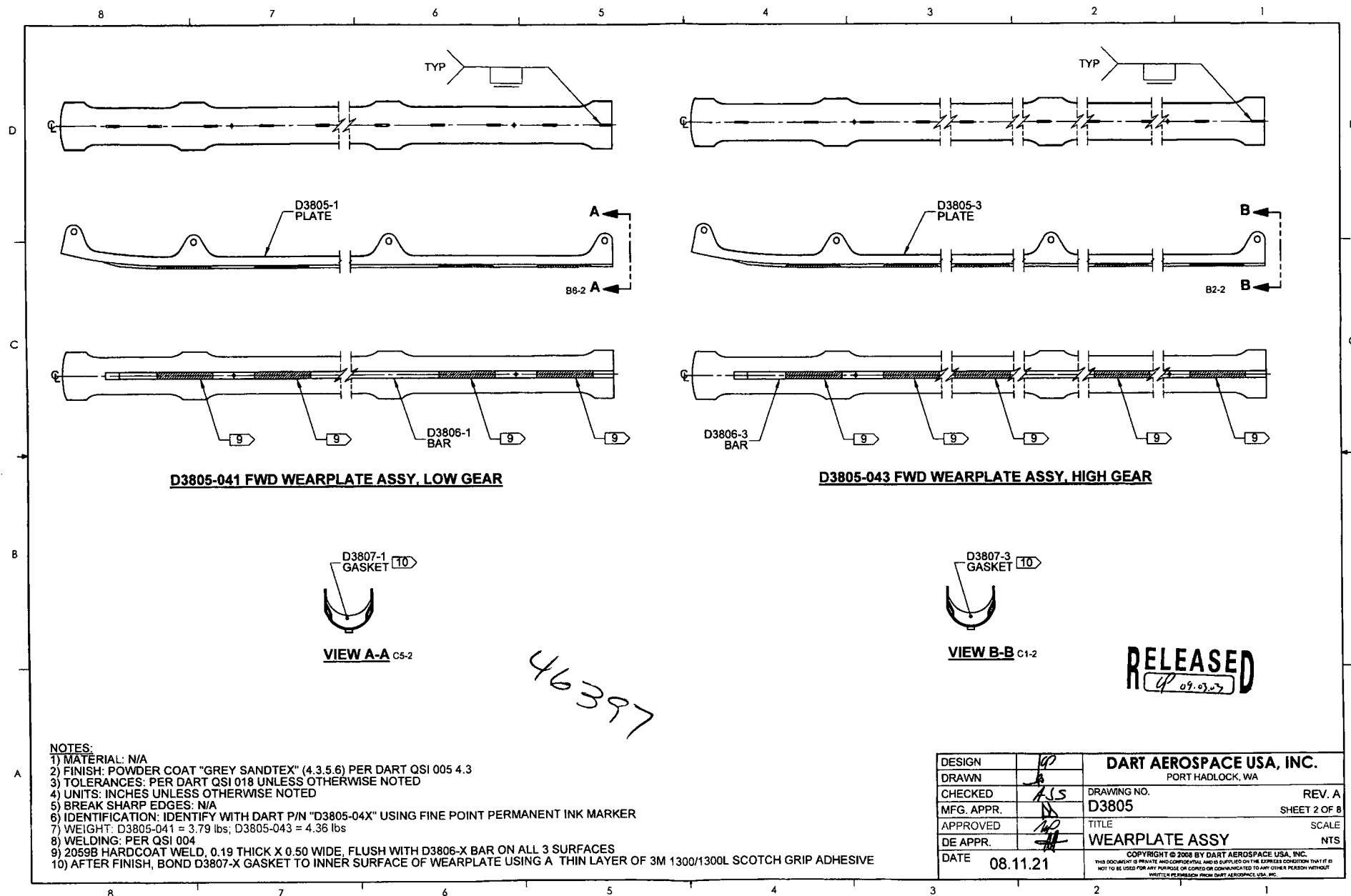
8 7 6 5 4 3 2 1

ITEM	QTY -041	QTY -043	QTY -045	QTY -047	P/N	DESCRIPTION
1	X				D3805-041	FWD WEARPLATE ASSY, LOW GEAR
2		X			D3805-043	FWD WEARPLATE ASSY, HIGH GEAR
3			X		D3805-045	AFT WEARPLATE ASSY, LOW GEAR
4				X	D3805-047	AFT WEARPLATE ASSY, HIGH GEAR
11	1				D3805-1	PLATE
12		1			D3805-3	PLATE
13			1		D3805-5	PLATE
14				1	D3805-7	PLATE
15	1				D3806-1	BAR
16		1			D3806-3	BAR
17			1		D3806-5	BAR
18				1	D3806-7	BAR
19	1				D3807-1	GASKET
20		1			D3807-3	GASKET
21			1		D3807-5	GASKET
22				1	D3807-7	GASKET
31	A/R	A/R	A/R	A/R	2059B	HARDCOAT
32	A/R	A/R	A/R	A/R	1300 (OR 1300L)	3M SCOTCH-GRIP ADHESIVE

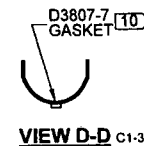
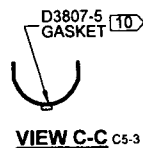
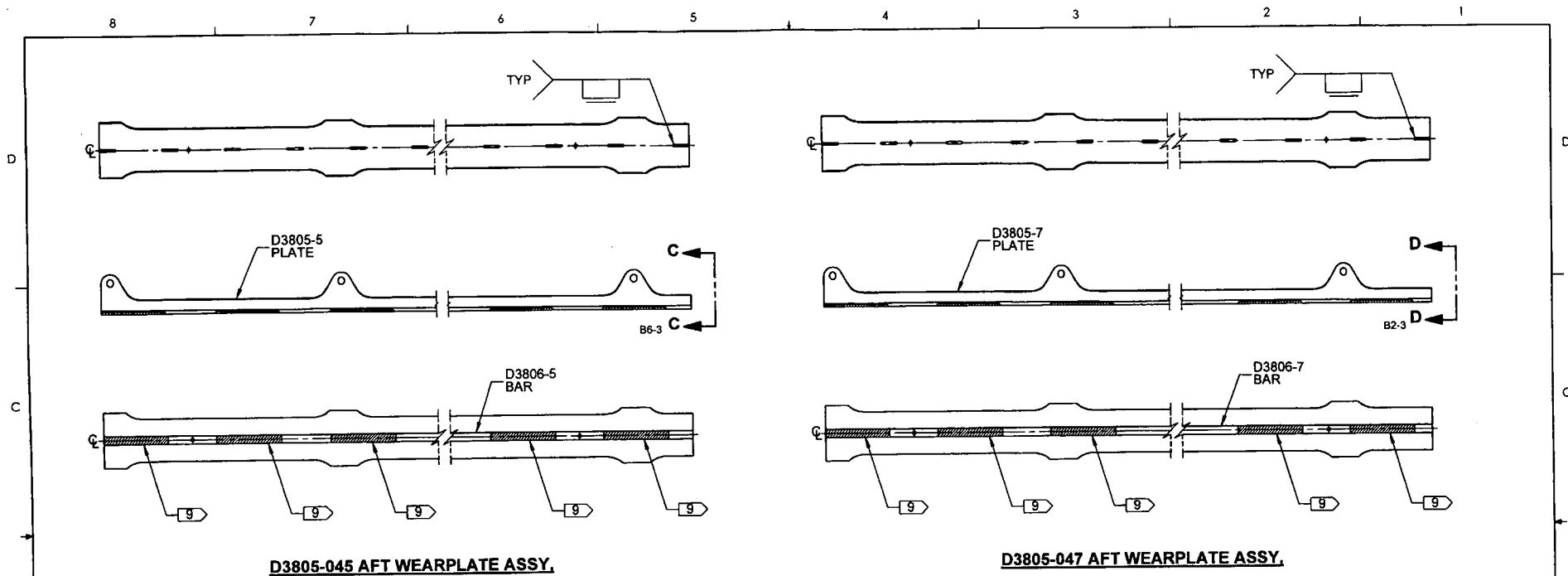
*10/16/97*

**RELEASED**  
*09.09.03*  
 per ECN 09-598

A	NEW ISSUE	MB	08.11.21
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>JP</i>	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	<i>JS</i>	PORT HADLOCK, WA	
CHECKED	<i>JS</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>JS</i>	D3805	SHEET 1 OF 8
APPROVED	<i>JS</i>	TITLE	SCALE
DE APPR.	<i>JS</i>	WEARPLATE ASSY	NTS
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MFG. APPR.	AS	D3805	SHEET 2 OF 8
APPROVED	JP	TITLE	SCALE
DE APPR.	JP	<b>WEARPLATE ASSY</b>	NTS
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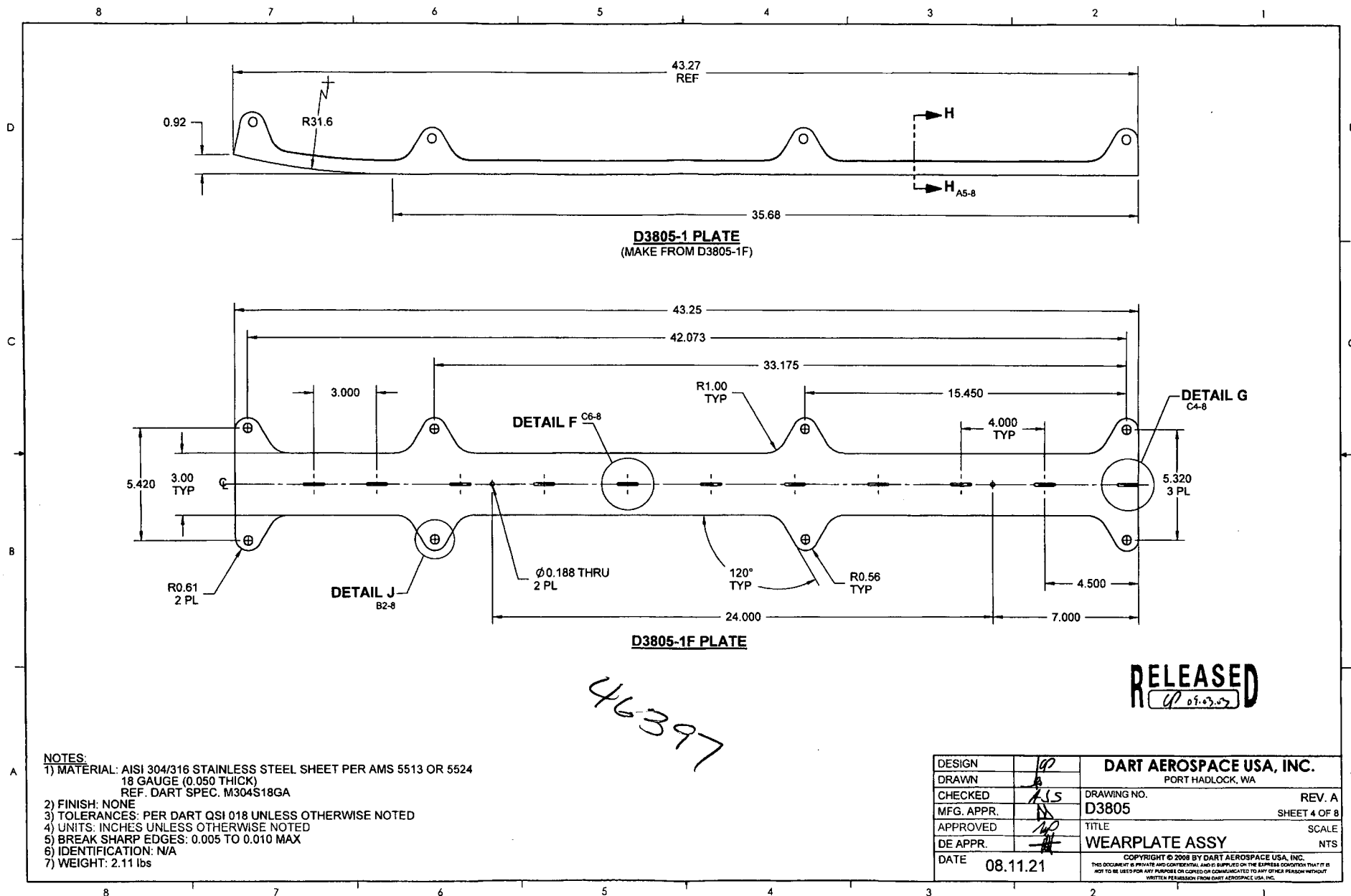


**RELEASED**  
09.03.07

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "GREY SANDEXT" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3805-04X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: D3805-045 = 3.93 lbs; D3805-047 = 4.21 lbs
- 8) WELDING: PER QSI 004
- 9) 2059B HARDCOAT WELD, 0.19 THICK X 0.50 WIDE, FLUSH WITH D3806-X BAR ON ALL 3 SURFACES
- 10) AFTER FINISH, BOND D3807-X GASKET TO INNER SURFACE OF WEARPLATE USING A THIN LAYER OF 3M 1300/1300L SCOTCH GRIP ADHESIVE

DESIGN	10	<b>DART AEROSPACE USA, INC.</b>	
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MFG. APPR.	15	D3805	SHEET 3 OF 8
APPROVED	15	TITLE	SCALE
DE APPR.	15	WEARPLATE ASSY	NTS
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**Dart Aerospace Ltd**

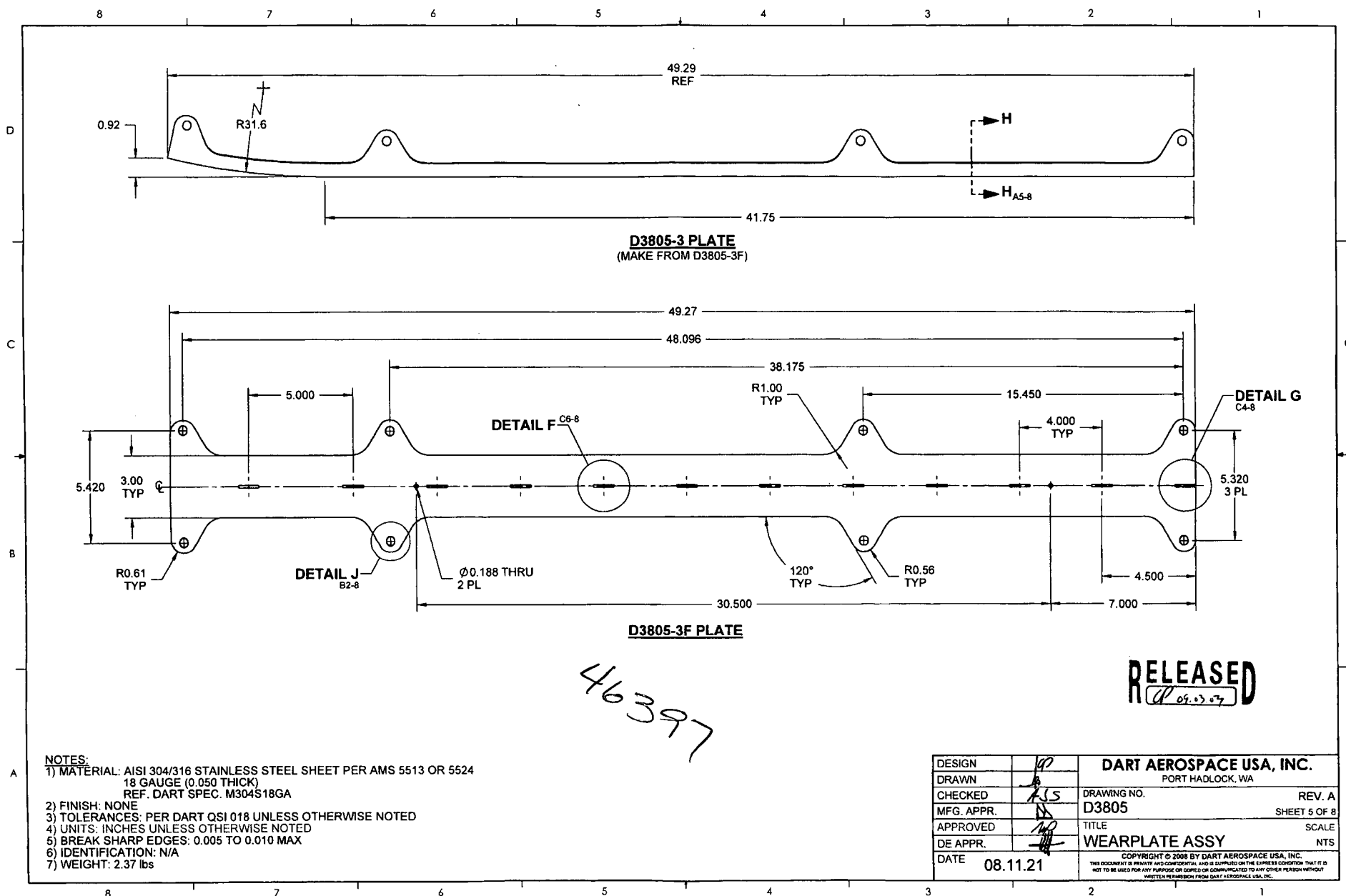
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



RELEASED  
CP 09-03-03

**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524  
18 GAUGE (0.050 THICK)  
REF. DART SPEC. M304S18GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 2.06 lbs

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CHECKED	<i>JS</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>JS</i>	D3805	SHEET 6 OF 8
APPROVED	<i>JP</i>	TITLE	SCALE
DE APPR.	<i>JP</i>	WEARPLATE ASSY	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

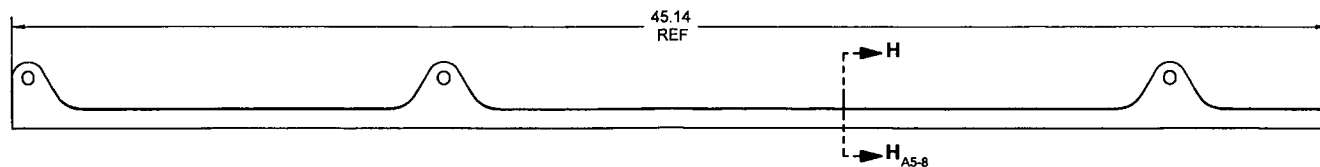
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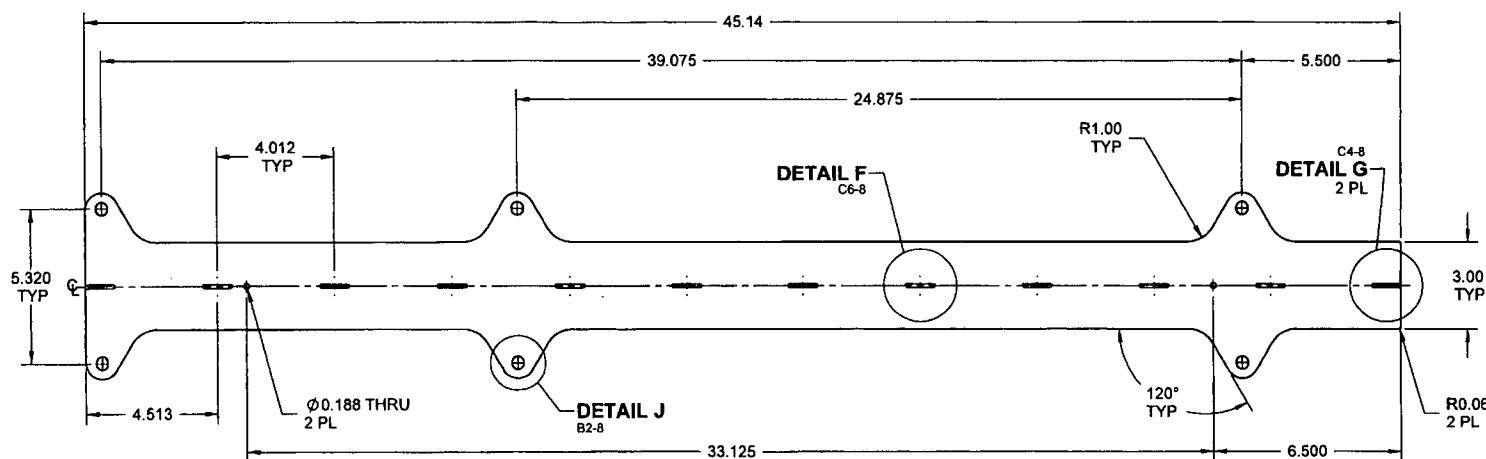
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

8 7 6 5 4 3 2 1



**D3805-7 PLATE**  
(MAKE FROM D3805-7F)



**D3805-7F PLATE**

**RELEASED**  
46397

**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524  
18 GAUGE (0.050 THICK)  
REF. DART SPEC. M304S18GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 2.13 lbs

DESIGN	46397	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	46397	PORT HADLOCK, WA	
CHECKED	46397	DRAWING NO.	REV. A
MFG. APPR.	46397	<b>D3805</b>	SHEET 7 OF 8
APPROVED	46397	TITLE	SCALE
DE APPR.	46397	<b>WEARPLATE ASSY</b>	NTS
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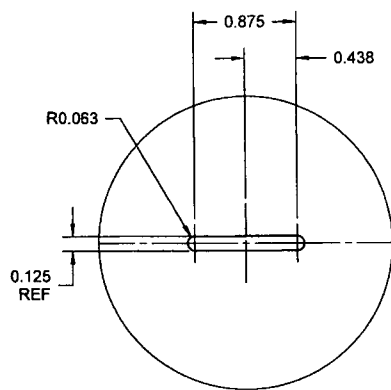
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

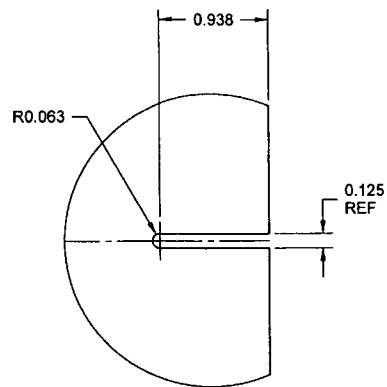
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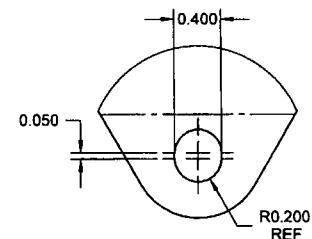
**DETAIL F**  
SLOT DETAIL TYP  
SCALE 4X

C5-4  
C5-5  
C4-6  
C4-7



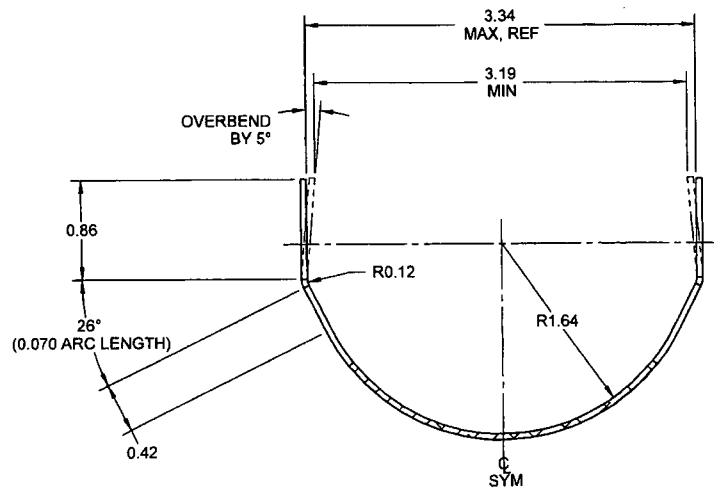
**DETAIL G**  
SLOT DETAIL TYP  
SCALE 4X

C1-4  
C1-5  
C1-6  
C2-7



**DETAIL J**  
SCALE 4X

B6-4  
B7-5  
B5-6  
B5-7



**SECTION H-H**  
SCALE 4X

D3-4  
D3-5  
D3-6  
D3-7

46397

**RELEASED**  
4709.09.03

DESIGN	197	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	8	PORT HADLOCK, WA	
CHECKED	215	DRAWING NO.	REV. A
MFG. APPR.	11	D3805	SHEET 8 OF 8
APPROVED	140	TITLE	SCALE
DE APPR.	11	WEARPLATE ASSY	NTS
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